Work Orde				*949	159*						Page 1
tem ID:	D2174-1 Web	renuuru maaten (filo ori ori ole ole ee	19 AND THE ATTEMPT OF	Accept	*N900	1 040	100)* '	Setup Start	I VI	S1* S2*
Start Date: Required Date: Reference:	1/02/13 1/18/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item Customer						
		an: <u>M</u> CJ				Date:			Run Star Stop	' *N ' *N	R1* R2*
Sequence ID/ Work Center ID)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp.
Draw Nbr	Re	vision Nbr									* Addition * Idea
D2174	Re	v E			. ==- =======						
100 *100* Waterjet		FLOW WATER JET Memo		0.00				6	o_		Jm13-2-6
FLOW CNC Waterje		1-Cut as po Deburr if n		ev: <u>E</u> Prog Rev:	<u>2</u> -						
*110 *110*		QC2- Inspect parts off	machine FAI/FAIB	0.00				6	8		Jm3-2
QC Quality Control		Memo		0.00							<u> </u>
120 *4 2 0 *		QC8- Inspect parts - se	cond check	0.00 \As 15				6			
120		Memo		0.00 13.2 8	}						

Quality Control

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	AANCE / UPD	ATE			
											QA Closed:	Date:	*
Work Ord	er.					DISPOSITION	i			AGAINST DE	PARTMENT	/PROCESS	
Part I	No.					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update		nitial	Actio	on	Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	Ch	ief Eng	Descrip	otion	Date	Verification	QC inspector
Doc/Data													
Equip/Tooling													
Operator													
Material							1						
Setup				ŀ									
Other				1									
Process													
Supplier							1						
Training							İ						
Unapproved													
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Landi	ng (Gear		_		General							
		Bending				Bend	Г	Grain			Ovalized		Pressure/Forced
		Centre No	ot Concer	ntric to C	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	ori Incomplete		Part Incorre	—	Weld
		Crushed/	Crimped.			Burrs		1 '	ions Incomplete/Ur	nclear	Part Lost/M	issing	Wrong Stock Pulled
	-	Cuffs	•		<u> </u>	Contamination		Mainte	•		Part Moved	- L	_
		Heat Trea	t			Countersink		Mislabe			Positioned \	Vrong	
		Inspection	n Strip in	Tube		Cut Too Short		Misread			Power Loss/		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord January-02-13				*940	159*					-,. .,	ويست . پوين د ستند	Page 2	
Item ID: Revision ID: Item Name:	D2174-1 Web		· · · · · · · · · · · · · · · · · · ·	Accept	*N900	040	100	*	Setup	Start Stop	14.	S1* S2*	-
Start Date: Required Date: Reference:	1/02/13 : 1/18/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item I Customer:	ID:							
Approvals:		an:			•	ate:				Start Stop	*NI *NI	R1* R2*	
Sequence ID/ Work Center I 130 *120* Small Fab Small Fab	D	Operation Description Small Fala Memo Deburr Stack	ans one	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp	
*140 *140* QC Quality Control		QC5- Inspect part compl	eteness to step on W/O	0.00									
150 *150* HandFinish		Chemical Conversion Co	oat per QSI005 4.1	0.00					6_	NG	130	2-20	

Hand Finishing

										DQA:	Date	:
NCR: Y	es / No				WORK ORDER NON-C	ONFO	RN	MANCE / UPDATE		0.161	D-1-	
					T .					QA Closed:	Date	2:
Work Orde					DISPOSITION			AGAINST	DE	PARTMENT	PROCESS	
WOIK OIGE	:r				Rework			Skid-tube Crosstube	Г		Water Jet	Engineering
Part N	io.				Scrap			Machining Small Fab		Pro	d. Eng. Coor.	Quality
		·			Use-as-is	l Th		oforming Finishing	$\overline{}$	4	e/Packaging	Other
NCR N	lo				Work Order Update			Large Fab Composite]	Supplier	
Root				Descri	ption of work order update	Initia	ıl	Action		Sign &		
Cause	Date	Step	Qty	•	or Non-conformance	Chief E	ng	Description		Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling							I					
Operator							1					
Material												•
Setup												
Other		1					Ì					
Process												
Supplier												.]
Training												
Unapproved		1				İ]				<u></u>	
						AULT CA	ATEC	GORY				
Landi	ng Gear				General					7	-	
	Bending			_	Bend	Gra			\vdash	Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to	o/s	BOM/Route	Hare				Over/Under		Temperature/Cure
	Cracks				Broken/Damaged	_ `		or Incomplete	L	Part Incorre	-	Weld
	Crushed/	Crimped.			Burrs	\vdash		ions Incomplete/Unclear	\vdash	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	\vdash		nance	\vdash	Part Moved		
	Heat Tre			<u> </u>	Countersink	Mis			L	Positioned V	_	\neg
	Inspection		Tube		Cut Too Short	Mis				Power Loss/	Surge	Other
	Ripples ii	n Bend			Drill Holes	Offs	et					

Out of Calibration

Outside Dimensions

Out of Sequence

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

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Work Order ID 949 January-02-13 11:23:46 AM		9/19/19										
Item ID: Revision ID: Item Name:	D2174-			Accept		1900		100)* s	Setup Sta	I VI	S1* S2*
Start Date: Required Date:	1/02/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*			Cust Item I Customer:	ID:					
Reference:		2004 2 60%			·	Justomeri						
Approvals:	Proces QC:	s Plan:	Date:	Tooling: SPC (Y/N):			ate:		F		op	R1* R2*
Sequence ID/ Work Center I		Operation Description		Set Up/ Run Hou	ırs	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp.
160		QC3- Inspect Part Finish		0.00	SHS							
160 QC Quality Control		Memo		0.00	3 2 20				6	·		
170		Identify as per dwg & St	ock Location:	0.00					ſ			8/11/2
170 Packaging Packaging		Memo	J	0.00					6			- 15102/70
180		QC21- Final Inspection	- Work Order Release	0.00						131	12/20	\mathcal{A}
*1				0.00					<u></u>	- V / [2/20	7
Quality Control		Мето		0.00								\
												ω_{c}

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1600 30

										DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-C	CONF	ORN	AANCE / UPDA				
										QA Closed:	Date:	
Work Orde	ar.				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Orac				 	Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo.				Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is	TI		noforming	Finishing		re/Packaging	Other
NCR N	lo				Work Order Update			Large Fab	Composite		Supplier	
			,									,
Root				l.	ption of work order update	Initi	- 1	Actio	•	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief	Eng	Descript	tion	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator	_											
Material		1										
Setup	_											
Other	_			ĺ								
Process	_											
Supplier												}
Training												
Unapproved		<u> </u>	<u> </u>	<u> </u>						l		
	•					AULT C	ATE	GORY				
Landir	ng Gear				General				-	1		1
	Bending				Bend	_	ain		<u> </u>	Ovalized	_	Pressure/Forced
,	Centre N	ot Conce	ntric to	o/s	BOM/Route		rdwa			Over/Under		Temperature/Cure
	Cracks			<u> </u>	Broken/Damaged	\vdash	•	ori Incomplete	:	Part Incorre		Weld
	Crushed/	Crimped.		<u> </u>	Burrs	-		ions Incomplete/Un	clear	Part Lost/M		Wrong Stock Pulled
	Cuffs			<u> </u>	Contamination	\vdash		nance		Part Moved		
	Heat Trea	at		<u> </u>	Countersink	∐ Мі	slabe	led	<u></u>	Positioned \		7
	Inspectio	n Strip in	Tube		Cut Too Short	Mi	sread	i	1	Power Loss/	'Surge	Other

Offset

Out of Calibration

Outside Dimensions

Out of Sequence

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

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Picklist Print

January-02-13 11:23:45 AM

Work Order ID:

94959

Parent Item:

D2174-1

Parent Item Name:

Web

Start Date: 1/02/13

Required Date: 1/18/13

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP C04.06.09ReformatKJ/RF

IPP Rev:D As per Rev E 06-11-22 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063 2024-T3 .063 sheet		Purchased	No			100	sf	218.8400	0.4722	1,9882104 2			JM13-2-
				Location		Loc Oty	Lo	oc Code					
				MAT022		218.84							
				1199	916	0.2			-				
				121	197	21.34							
				1236	654	12.8							
				123	701	184.5			123	701			

										DQA:	Date:	
NCR:	Yes / No				WORK ORDER NON-O	CONF	ORN	MANCE / UPDATE			•	
										QA Closed:	Date:	
Work Orde	or.				DISPOSITION			AGAINS	T DE	PARTMENT/	PROCESS	
Part f	No				Rework Scrap Use-as-is Work Order Update		N Therm	Skid-tube Crosstube Machining Small Fal noforming Finishin Large Fab Composite	6		Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root				Descri	tion of work order update	Init	tial	Action		Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief	- 1	Description		Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling		i i										
Operator				[
Material						1						
Setup												
Other								•				
Process												
Supplier												
Training												:
Unapproved		<u> </u>										
					F.	AULT (CATE	GCIRY				
Landi	ng Gear				General	_				•	_	_
	Bending				Bend	G	rain		L	Ovalized	L	Pressure/Forced
	Centre N	ot Conce	ntric to	o/s	BOM/Route	Ha	ardwa	re	L	Over/Under	tolerance	Temperature/Cure
	Cracks	•			Broken/Damaged	∐ In	specti	on Incomplete		Part Incorred	:t	Weld
	Crushed/	Crimped			Burrs	ШIn	structi	ions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs			- 1	Contamination	I IM	lainte	nance		Part Moved		

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

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DART AEROSPACE LTD	Work Order:	94959
Description: Web	Part Number:	D2174-1
Inspection Dwg: D2174 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

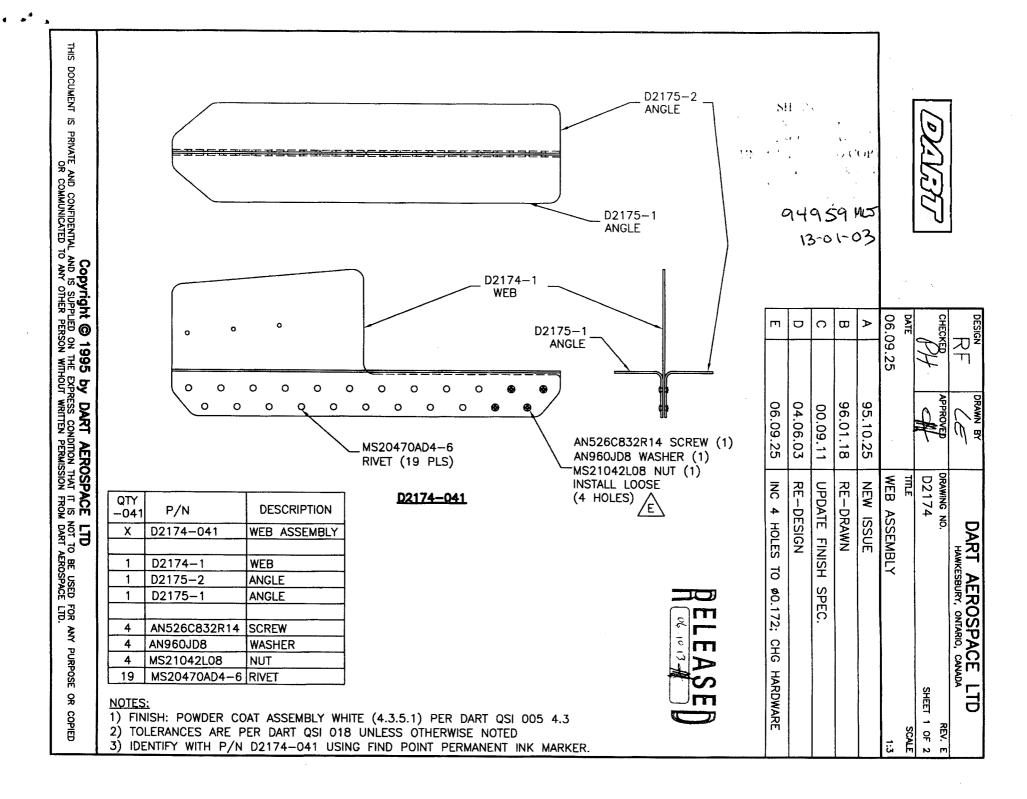
X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.250	+/-0.010	6.258"	_	`	V	Jamos
6.400	+/-0.010	6400°	_		V	
4.800	+/-0.010	4.809"	_		V	
1.375	+/-0.010	1.383"	_		V	
1.050	+/-0.005	1.383"	_		V	
Ø0.128	+0.005/-0.001	0,138,	_		V	
12.650	+/-0.010	12.6.50	_		T	Jemoc
0.550	+/-0.010	0.556"	-		V	
0.900	+/-0.010	0.907"	-		V	
1.629	+/-0.010	1.637"	_		V	
1.506	+/-0.005	1.510"	~		V	
11.550	+/-0.005	11.557"	_		_V	Rodunca
50°	+/-0.5°	.500	-		Protector	
0.063 thick	+/-0.010	0.064"	_		\/	
Ø0.172	+0.005/-0.001	0.172°	-		ν	
			DAS			

Measured by: Jm Audited by: 3-29 Prototype Approval: N/A

Date: 13-2-8 Date: 13-2-P Date: N/A

Rev	Date	Change	Revised by	Approved
Α	04.08.12	New Issue	KJ/JLM 140	-1
В	07.04.02	Ø0.172 dimension added	KJ/JLM	Sill



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THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. 6.250 85 R0.35 (TYP) 3.012 (1.506 PITCH) 1.629 Ø0.172 (4 HOLES) 4.283 RO.13 4.800 06.09.25 0.500 GRAIN 6.400 2.692 DIRECTION 50 0 (TYP) 0.900 0.821 0 0 0 Ø0.128 (22 HOLES) └- o.300 1.375 1.075 10.500 (1.050 PITCH) 0.550 -11.550 (1.050 PITCH) DRAWING NO. WEB D2174-1 DART AEROSPACE I NOTES: MATERIAL: 2024-T3 SHEET (QQ-A-200/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED BREAK ALL SHARP EDGES 0.005 TO 0.010 5) ALL DIMENSION ARE IN INCHES SHEET OR COPIED 2 OF 2 SCALE 1:3